

Date: Wednesday, 10/11/2006 10:29:12 AM
 User: Kim Johnston

Process Sheet

Customer : CU-DAR001 Dart Helicopters Services
 Job Number : 28891
 Estimate Number : 12550
 P.O. Number :
 This Issue : 10/11/2006 S.O. No. :
 Prsht Rev. : NC
 First Issue : // Type : LANDING GEAR
 Previous Run :
 Written By :
 Checked & Approved By : 06 10 11
 Comment : Est Rev:A New Issue 06-10-06 JLM

Drawing Name : FLOAT SKID LH

Part Number : D206642514

Drawing Number : IIN D206-642 REV J Rev L

Project Number : N/A

Drawing Revision : Rev. L

Material :

Due Date : 11/5/2006

Qty:

1 Um:

Each

Additional Product

Job Number:



Seq. #:

Machine Or Operation:

Description :

1.0

DC

DOCUMENT CONTROL



S080629



Comment: DOCUMENT CONTROL

Photocopy bluefile and create labels per PPP D206-642-513 CH0001

CH0002 P08.04.26

2.0

28891A

FLOAT SKIDTUBE ASSEMBLY



Comment: Sub-Component FLOAT SKIDTUBE ASSEMBLY

D206-642-545

Batch: 28891A

SP

3.0

PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Pick Packing Kit

4.0

D206648013

GHW Kit



Comment: Qty.: 1.0000 Each(s)/Unit Total: 1.0000 Each(s)

Pick:

Qty Part Number

Description

Batch

1 D206-648-013 GHW Kit

37418

1 D206-642-541(REF)

SP

5.0

D2652

Bushing



Comment: Qty.: 16.0000 Each(s)/Unit Total: 16.0000 Each(s)

Pick:

Qty Part Number

Description

Batch

16 D2652

Bushing

38745

8/5/6

SP

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Date: Wednesday, 10/11/2006 10:29:13 AM
User: Kim Johnston

Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: FLOAT SKID LH

Job Number: 28891

Part Number: D206642514

Job Number:



Seq. #:

Machine Or Operation:

Description :

6.0

D2712

Set Screw



Comment: Qty.: 10.0000 Each(s)/Unit Total : 10.0000 Each(s)

Pick:

Qty Part Number

Description

Batch

10 D2712

Set Screw

34628

SP

7.0

D29322

206 Saddle Right side



Comment: Qty.: 1.0000 Each(s)/Unit Total : 1.0000 Each(s)

Pick:

Qty Part Number

Description

Batch

1 D2932-2

Saddle

37865

SP

8.0

D29332

206 Saddle Right



Comment: Qty.: 1.0000 Each(s)/Unit Total : 1.0000 Each(s)

Pick:

Qty Part Number

Description

Batch

1 D2933-2

Saddle

37423

SP

9.0

D2934

Saddle Spacer



Comment: Qty.: 2.0000 Each(s)/Unit Total : 2.0000 Each(s)

Pick:

Qty Part Number

Description

Batch

2 D2934

Saddle Spacer

37328

SP

10.0

D2935

Saddle Spacer



Comment: Qty.: 2.0000 Each(s)/Unit Total : 2.0000 Each(s)

Pick:

Qty Part Number

Description

Batch

2 D2935

Saddle Spacer

37867

8/5/6

SP

11.0

D29382

206 Saddle Right side



Comment: Qty.: 1.0000 Each(s)/Unit Total : 1.0000 Each(s)

Pick:

Qty Part Number

Description

Batch

1 D2938-2

Saddle

1539131

8/6/13

SP

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Date: Wednesday, 10/11/2006 10:29:13 AM
User: Kim Johnston

Process Sheet

Customer: CU-DAR001 Dark Helicopters Services

Drawing Name: FLOAT SKID LH

Job Number: 28891

Part Number: D206642514

Job Number:



Seq. #:

Machine Or Operation:

Description :

12.0

D29392

206 Saddle Right Side



Comment: Qty.: 1.0000 Each(s)/Unit Total: 1.0000 Each(s)

Pick:

Qty Part Number

Description

Batch

1 D2939-2

Saddle

36144

SP

13.0

D3407043

Tow Ring



Comment: Qty.: 1.0000 Each(s)/Unit Total: 1.0000 Each(s)

Pick:

Qty Part Number

Description

Batch

1 D3407-043

Tow Ring

57372

SP

14.0

D34561

washer



Comment: Qty.: 1.0000 Each(s)/Unit Total: 1.0000 Each(s)

Pick:

Qty Part Number

Description

Batch

1 D3456-1

Washer

33275

SP

15.0

AN3C7A

BOLT



Comment: Qty.: 4.0000 Each(s)/Unit Total: 4.0000 Each(s)

BOLT

Batch:

105906

SP

16.0

D34571

Inventory



Comment: Qty.: 2.0000 Each(s)/Unit Total: 2.0000 Each(s)

Pick:

Qty Part Number

Description

Batch

2 D3457-1

Washer

37123

SP

17.0

AN3C35A



Comment: Qty.: 3.0000 Each(s)/Unit Total: 3.0000 Each(s)

Pick:

Qty Part Number

Description

Batch

3 AN3C35A

Bolt

107463

81516

SP

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
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Date: Wednesday, 10/11/2006 10:29:13 AM
User: Kim Johnston

Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: FLOAT SKID LH

Job Number: 28891

Part Number: D206642514

Job Number:



Seq. #:

Machine Or Operation:

Description :

18.0

AN3C36A



Comment: Qty.: 34.0000 Each(s)/Unit Total : 34.0000 Each(s)

Pick:

Qty Part Number

Description

Batch

34 AN3C36A

Bolt

106541

scf

19.0

AN3C41A



Comment: Qty.: 8.0000 Each(s)/Unit Total : 8.0000 Each(s)

AN3C41A

Batch:

107463

scf

20.0

AN4C6A

Bolt



Comment: Qty.: 12.0000 Each(s)/Unit Total : 12.0000 Each(s)

Bolt

106519

scf

21.0

AN5C11A



Comment: Qty.: 8.0000 Each(s)/Unit Total : 8.0000 Each(s)

Pick:

Qty Part Number

Description

Batch

8 AN5C11A

Bolt

107013

(-1)

scf

22.0

AN5C15A

Bolt



Comment: Qty.: 1.0000 Each(s)/Unit Total : 1.0000 Each(s)

Pick:

Qty Part Number

Description

Batch

1 AN5C15A

Bolt

101291

scf

23.0

AN5C32A



Comment: Qty.: 2.0000 Each(s)/Unit Total : 2.0000 Each(s)

Pick:

Qty Part Number

Description

Batch

2 AN5C32A

Bolt

105746

8/5/6

scf

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Date: Wednesday, 10/11/2006 10:29:13 AM
User: Kim Johnston

Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: FLOAT SKID LH

Job Number: 28891

Part Number: D206642514

Job Number:



Seq. #:

Machine Or Operation:

Description :

24.0

AN5C34A



Comment: Qty.: 2.0000 Each(s)/Unit Total : 2.0000 Each(s)

Pick:

Qty Part Number

Description

Batch

2 AN5C34A

Bolt

107289

Scp

25.0

AN5C35A



Comment: Qty.: 1.0000 Each(s)/Unit Total : 1.0000 Each(s)

Pick:

Qty Part Number

Description

Batch

1 AN5C35A

Bolt

107551

Scp

26.0

AN960C10L

washer



Comment: Qty.: 78.0000 Each(s)/Unit Total : 78.0000 Each(s)

Pick:

Qty Part Number

Description

Batch

78 AN960C10L

Washer

107534

Scp

27.0

AN960C416L

WASHER



Comment: Qty.: 24.0000 Each(s)/Unit Total : 24.0000 Each(s)

Pick:

Qty Part Number

Description

Batch

24 AN960C416L

Washer

107008

Scp

28.0

AN960C516L

WASHER



Comment: Qty.: 8.0000 Each(s)/Unit Total : 8.0000 Each(s)

Pick:

Qty Part Number

Description

Batch

8 AN960C516L

Washer

103544

8/5/10

Scp

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Date: Wednesday, 10/11/2006 10:29:14 AM
User: Kim Johnston

Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: FLOAT SKID LH

Job Number: 28891

Part Number: D206642514

Job Number:



Seq. #:

Machine Or Operation:

Description :

29.0

MS210433

Nut



Comment: Qty.: 49.0000 Each(s)/Unit Total : 49.0000 Each(s)

Pick:

Qty Part Number

Description

Batch

49 MS21043-3

Nut 107288

Handwritten notes and signatures

50

30.0

MS210434

Nut



Comment: Qty.: 13.0000 Each(s)/Unit Total : 13.0000 Each(s)

Pick:

Qty Part Number

Description

Batch

13 MS21043-4

Nut 107285

30

31.0

MS210435

Nut



Comment: Qty.: 4.0000 Each(s)/Unit Total : 4.0000 Each(s)

Pick:

Qty Part Number

Description

Batch

4 MS21043-5Nut

105430

50

32.0

NAS1515H3L

WASHER



Comment: Qty.: 78.0000 Each(s)/Unit Total : 78.0000 Each(s)

Pick:

Qty Part Number

Description

Batch

78 NAS1515H3L

Washer M106516

Handwritten notes and signatures

33.0

NAS1515H4L

Inventory



Comment: Qty.: 24.0000 Each(s)/Unit Total : 24.0000 Each(s)

Pick:

Qty Part Number

Description

Batch

24 NAS1515H4L

Washer 101542 (8x)

Handwritten notes: M102029 (164), 8/5/5

Handwritten notes: (PK), 56

Dart Aerospace Ltd

W/O:		WORK ORDER CHANGES						
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector	
8/9/26	#32	NAS1515H3C has been replaced By D3672-1 Per Rev L. B# <u>B3927549</u> (+78) AS 08/09/26 (+78)				CP 08.09.26 PC AS1042	S 8/9/26	
8/9/26	#33	NAS1515H3C NAS1515H4C Has been replaced By D3672-3 Per Rev L. B# <u>41775</u> (+24) AS 08/09/26 (+24)				CP 08.09.26 PC AS1042	S 8/9/26	

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Date: Wednesday, 10/11/2006 10:29:14 AM
User: Kim Johnston

Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: FLOAT SKID LH

Job Number: 28891

Part Number: D206642514

Job Number:



Seq. #:

Machine Or Operation:

Description :

34.0

NAS1515H5L

WASHER



(P10)

Comment: Qty.: 8.0000 Each(s)/Unit Total : 8.0000 Each(s)

Pick:

Qty Part Number Description Batch
8 NAS1515H5L Washer 106541

54

35.0

NAS1515H5

Washer



(P10)

Comment: Qty.: 16.0000 Each(s)/Unit Total : 16.0000 Each(s)

Pick:

Qty Part Number Description Batch
16 NAS1515H5 Washer M106541 12X

M106541 3X

54

36.0

D33963

Inventory



Comment: Qty.: 2.0000 Each(s)/Unit Total : 2.0000 Each(s)

Spacer

Batch: 34741

50

37.0

D34521

Bracket



Comment: Qty.: 2.0000 Each(s)/Unit Total : 2.0000 Each(s)

Bracket

Batch: 28950

54

38.0

D34523

Bracket



Comment: Qty.: 1.0000 Each(s)/Unit Total : 1.0000 Each(s)

Bracket

Batch: B28951

50

39.0

MS21919WDG28

Inventory



Comment: Qty.: 4.0000 Each(s)/Unit Total : 4.0000 Each(s)

Clamp

Batch: M18847

8/5/5

50

Dart Aerospace Ltd

W/O:		WORK ORDER CHANGES						
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector	
8/9/26	#34	NAS 1515 HSL has been replaced by D3672-7 Per Rev L. B# B35522 (FE) AS 08/09/26 (VR)				CP 08.09.26 PL AS/042	8/9/26	
8/9/26	35	NAS 1515 HS has been replaced by D3672-5 Per Rev L. B# B35521 (FE) AS 08/09/26 (VR)				CP 08.09.26 PL AS/042	8/9/26	

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____
 QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Date: Wednesday, 10/11/2006 10:29:14 AM
User: Kim Johnston

Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: FLOAT SKID LH

Job Number: 28891

Part Number: D206642514

Job Number:



Seq. #:

Machine Or Operation:

Description :

40.0

QC4

INSPECT 100% KITS FOR COMPLETENESS



CHECK KIT AGAINST PART LIST
PER IN-D206-642 Rev. L



Comment: INSPECT 100% KITS FOR COMPLETENESS

S 08/09/29 (20)

41.0

PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Identify and pack for shipping as per PPP D206-642-511

Location: B

CU 8/9/29 (1)

42.0

QC21

FINAL INSPECTION/W/O RELEASE



Comment: FINAL INSPECTION/W/O RELEASE

D 08/09/29

Job Completion



UNK 08-09-29

28891A

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

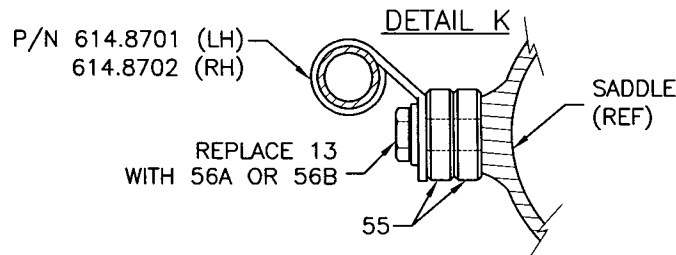
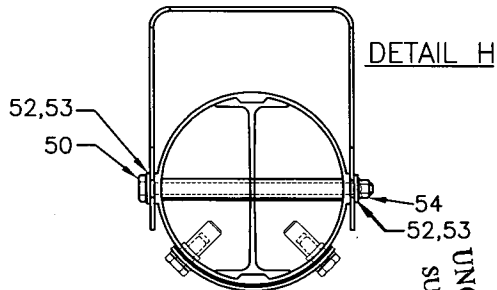
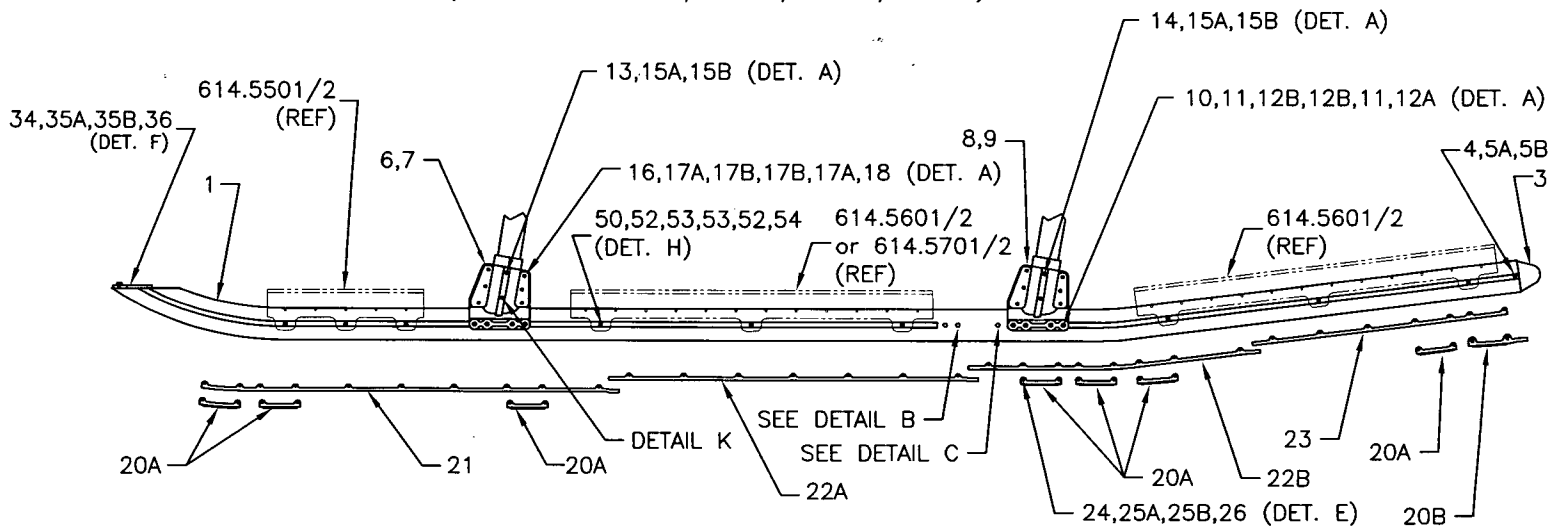
Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

206 A/B FLOAT SKIDTUBES (TRI-BAG FLOATS)
(D206-642-611/-612/-613/-614)



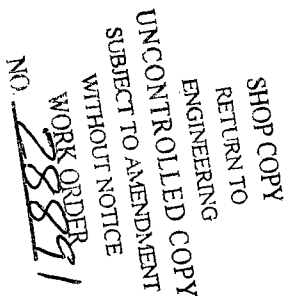
SHOP COPY
RETURN TO
ENGINEERING
UNCONTROLLED COPY
SUBJECT TO AMENDMENT
WITHOUT NOTICE
WORK ORDER
NO. 28891

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Revision: J
Date: 05.08.30

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Revision: J
Date: 05.08.30

Date: Wednesday, 10/11/2006 10:29:12 AM
 User: Kim Johnston

Process Sheet

Customer	: CU-DAR001 Dart Helicopters Services	Drawing Name	: FLOAT SKID LH
Job Number	: 28891	Part Number	: D206642514
Estimate Number	: 12550	Drawing Number	: IIN D206-642 REV J
P.O. Number	:	Project Number	: N/A
This Issue	: 10/11/2006 S.O. No. :	Drawing Revision	: J
Prsht Rev.	: NC	Material	:
First Issue	: / / Type : LANDING GEAR	Due Date	: 11/5/2006 Qty: 1 Um: Each
Previous Run	:		
Written By	: <u> </u>		
Checked & Approved By	: <u> </u>		
Comment	: Est Rev:A New Issue 06-10-06 JLM		

Additional Product

Job Number:



Seq. #:	Machine Or Operation:	Description :
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1.0 DC

DOCUMENT CONTROL



JL008-5.05



Comment: DOCUMENT CONTROL

Photocopy bluefile and create labels per PPP D206-642-513 CHG001

2.0

28891A

FLOAT SKIDTUBE ASSEMBLY



Comment: Sub-Component FLOAT SKIDTUBE ASSEMBLY

D206-642-545

Batch:

3.0

PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Pick Packing Kit

4.0

D206648013

GHW Kit



Comment: Qty.: 1.0000 Each(s)/Unit Total : 1.0000 Each(s)

Pick:

Qty Part Number Description Batch

1 D206-648-013 GHW Kit 1 D206-642-541(REF)

5.0

D2652

Bushing



Comment: Qty.: 16.0000 Each(s)/Unit Total : 16.0000 Each(s)

Pick:

Qty Part Number Description Batch

16 D2652 Bushing

4.6 206L/L-1/L-3/L-4/407 High Gear Float Skidtubes (OEM/PMA BAG COMPATIBLE)

Item	Qty -513	Qty -514	Qty -545	Qty -547	Qty -013	Part Number	Description
	X					D206-642-513	SKIDTUBE INSTALLATION, LH
		X				D206-642-514	SKIDTUBE INSTALLATION, RH
	1	1	X			D206-642-545	SKIDTUBE ✓
				X		D206-642-547	WEARSHOE KIT (REPLACES -543 KIT)
	1	1			X	D206-648-013	GROUND HANDLING KIT ✓
1			1			D3274-043	SKIDTUBE ASSEMBLY
3			1			D2646	* AFT CAP ⁽¹⁾
4			2			AN3C4A	* BOLT ⁽¹⁾
5A			2			AN960C10L	* WASHER ⁽¹⁾
5B			2			D3672-1	* WASHER (REPLACES NAS1515H3L) ⁽¹⁾
6	1					D2932-1	SADDLE, FWD OUT, LH
6		1				D2932-2	SADDLE, FWD OUT, RH ✓
7	1					D2933-1	SADDLE, FWD IN, LH
7		1				D2933-2	SADDLE, FWD IN, RH ✓
8	1					D2938-1	SADDLE, AFT OUT, LH
8		1				D2938-2	SADDLE, AFT OUT, RH ✓
9	1					D2939-1	SADDLE, AFT IN, LH
9		1				D2939-2	SADDLE, AFT IN, RH ✓
10	8	8				AN3C41A	BOLT
11	16	16				D2652	BUSHING ✓
12A	8	8				MS21043-3	NUT ✓
12B	16	16				D3672-5	WASHER (REPLACES NAS1515H5) ?
13	4	4				AN5C11A (or AN5C12A)	* BOLT ⁽²⁾ ✓
14	4	4				AN5C11A (or AN5C12A)	* BOLT ⁽²⁾ ✓
15A	8	8				AN960C516L	WASHER ✓
15B	8	8				D3672-7	WASHER (REPLACES NAS1515H5L) ?
16	12	12				AN4C6A	BOLT ✓
17A	24	24				D3672-3	WASHER (REPLACES NAS1515H4L) ?
17B	24	24				AN960C416L	WASHER ✓
18	12	12				MS21043-4	NUT ✓
20A			9	9		D3537-1	* WEARPAD ⁽¹⁾ (REPLACES D2648-3)
21A			1	1		D3537-3	* WEARPAD ⁽¹⁾ (REPLACES D3429-1)
22A			1	1		D3535-15	* WEARSHOE ⁽¹⁾ (REPLACES D2656-15)
22B			1	1		D3536-15	* GASKET ⁽¹⁾
23A			1	1		D3535-23	* WEARSHOE ⁽¹⁾ (REPLACES D2656-23)
23B			1	1		D3536-23	* GASKET ⁽¹⁾
24A			1	1		D3535-39	* WEARSHOE ⁽¹⁾ (REPLACES D3287-1)
24B			1	1		D3536-39	* GASKET ⁽¹⁾
25A			1	1		D3535-35	* WEARSHOE ⁽¹⁾ (REPLACES D2656-35)
25B			1	1		D3536-35	* GASKET ⁽¹⁾
26A			78	78		AN3C4A	* BOLT ⁽¹⁾
26B			78	78		AN960C10L	* WASHER ⁽¹⁾
26C			78			ALS7-1032-130	* INSERT ⁽¹⁾ (or AKS4-1032-130, ALS4-1032-130, AELS-1032-130)
30	1	1				D3407-043	TOW RING ✓
32A	1	1				D3456-1	WASHER ✓
32B	2	2				D3457-1	WASHER ✓
33	1	1				MS21043-4	NUT ✓
34			1			AN4C5A	BOLT
35			1			AN960C416	WASHER
36			1			D3413-1	RING
37	10	10				D2712	SET SCREW ✓
38	2	2				D2934	SADDLE SPACER ✓
39	2	2				D2935	SADDLE SPACER ✓

continued on next page...

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Revision: L

Date: 07.10.25

continued from previous page...

Item	Qty -513	Qty -514	Qty -545	Qty -547	Qty -013	Part Number	Description
40					2	D3414-041	LUG ASSEMBLY (GHW)
41					4	AN3C37A	BOLT
42					8	D2652	BUSHING
43					4	MS21043-3	NUT
44					4	AN960C10	WASHER
50	34	34				AN3C36A	BOLT
51	3	3				AN3C35A	BOLT
52	74	74				AN960C10L	WASHER
53	74	74				D3672-1	WASHER (REPLACES NAS1515H3L)
54	37	37				MS21043-3	NUT
55	2	2				D3396-3	SPACER
56A	1	1				AN5C35A	BOLT
56B	1	1				AN5C15A	BOLT
60	2	2				AN5C32A	BOLT
61	2	2				AN5C34A	BOLT
62	4	4				MS21043-5	NUT
70	2	2				D3452-1	BRACKET
71	1	1				D3452-3	BRACKET
72	4	4				MS21919WDG-28	CLAMP
73	4	4				AN3C7A	BOLT
74	4	4				AN960C10L	WASHER
75	4	4				D3672-1	WASHER (REPLACES NAS1515H3L)
76	4	4				MS21043-3	NUT

NOTES: (1) DENOTES THAT PART IS INCLUDED WITH D3274-043 ASSEMBLY ABOVE
 (2) CHOICE OF BOLT WILL DEPEND ON CROSSTUBE (SEE INSTALLATION PROCEDURE)

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Revision: L
 Date: 07.10.25

THE
JOURNAL
OF
THE
ROYAL
ANTHROPOLOGICAL
INSTITUTE
OF GREAT
BRITAIN
AND IRELAND
VOLUME
LXXV
PART I
1945

Date: Wednesday, 10/11/2006 10:30:12 AM
 User: Kim Johnston

Process Sheet

Customer	: CU-DAR001 Dart Helicopters Services	Drawing Name	: FLOAT SKIDTUBE ASSEMBLY
Job Number	: 28891A		
Estimate Number	: 12548		
P.O. Number	:	Part Number	: D206642545
This Issue	: 10/11/2006 S.O. No. :	Drawing Number	: D3274 REV C <i>Rev D</i>
Prsht Rev.	: NC	Project Number	: N/A
First Issue	: 1/1 Type : LANDING GEAR	Drawing Revision	: <i>CD</i>
Previous Run	: 28890A	Material	:
Written By	:	Due Date	: 11/5/2006 Qty: 1 Um: Each
Checked & Approved By	: <i>061011</i>		
Comment	: Est Rev: A New Issue 06-10-06 JLM		

Additional Product

Job Number:



Seq. #:	Machine Or Operation:	Description :
---------	-----------------------	---------------

1.0

DC

DOCUMENT CONTROL



Comment: DOCUMENT CONTROL

Photocopy bluefile & type labels per PPP D206-642-545 CHG001

CHG 002 06-05-26

2.0

D26001240

Extrusion Round 3" 206



Comment: Qty.: 1.0000 Each(s)/Unit Total: 1.0000 Each(s)

Pick:

Qty Part Number Description Batch

1 D2600-1-240 3" OD Tube *B31032**DP**7-11-19*

3.0

LANDING GEAR 1

LANDING GEAR RESOURCE 1



Comment: LANDING GEAR RESOURCE 1

1-Cut D2600-1 to 190.00" in length as per Dwg D3274 and Deburr ends

2-Drill #40 Aft cap pilot hole using DT8025

3-Cleco DT8025 in position and install pilot hole drill Jig DT8891 A,BC & D Drill 3/16" & 1/8" pilot holes as per Dwg D3274

4-Remove inner indexing ridge on aft end of skidtube as per Dwg D3274

5-Open aft end cap holes to Ø0.208" as per Dwg D3274. Deburr aft end.

DP
7-11-19

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Date: Wednesday, 10/11/2006 10:30:12 AM
User: Kim Johnston

Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: FLOAT SKIDTUBE ASSEMBLY

Job Number: 28891A

Part Number: D206642545

Job Number:



Seq. #:

Machine Or Operation:

Description :

4.0

HAND FINISHING1

HAND FINISHING RESOURCE #1



Comment: HAND FINISHING RESOURCE #1

Acid Etch and Alodine tube as per QSI 005 4.1

DP 2-11-19

5.0

QC3

INSPECT POWDER COAT/CHEMICAL CONVERSION



Comment: INSPECT POWDER COAT/CHEMICAL CONVERSION

RE 08-04-07

6.0

D3282041

I-Beam



Comment: Qty.: 1.0000 Each(s)/Unit Total: 1.0000 Each(s)

Pick:

Qty Part Number Description Batch

1 D3282-041 Float Web

37052

SL 8-4-7

7.0

LANDING GEAR 1

LANDING GEAR RESOURCE 1



Comment: LANDING GEAR RESOURCE 1

1-Open 1/8" PILOTS TO Ø0.313" crossbolt spacer holes as per Dwg D3274

2-Open 3/16" Pilots to Ø0.375" crossbolt spacer holes as per Dwg D3274

3-Deburr crossbolt spacer holes as per Dwg D3274 and blow out chips from inside the tube

4-Bond web in place as per Dwg D3274 & QSI 015.

A/R Sikaflex-291

Sikaflex expire date:

Start:

Finish:

(Adhere for 12 hours)

107397

8-7-31

8-4-7

Time: 1:15

Time: 9:45AM

SL 8-4-7

8.0

QC5

INSPECT WORK TO CURRENT STEP



Comment: INSPECT WORK TO CURRENT STEP

8 08/04/08 (EO)

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Date: Wednesday, 10/11/2006 10:30:12 AM
User: Kim Johnston

Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: FLOAT SKIDTUBE ASSEMBLY

Job Number: 28891A

Part Number: D206642545

Job Number:



Seq. #:

Machine Or Operation:

Description:

9.0

LANDING GEAR 1

LANDING GEAR RESOURCE 1



Comment: LANDING GEAR RESOURCE 1

1-Bend tube using program D3274 as per Dwg D3274. Install drop pins in cross bolt spacer holes to maintain web position.

2-Cut Fwd end of tube to length as per Dwg D3274

3-Remove inner indexing ridge on Fwd end of skidtube as per Dwg D3274

4- DRILL PILOT HOLES FOR WEARPLATES USING D3274-1T2
OPEN HOLES TO .1875

5- C'SINK WITH 3/16 C'SINK BIT (ENSURE NOT TO C'SINK TO DEEP)

6- OPEN HOLES TO .257 AS PER DRWG D3274

7- FINISH C'SINK WITH .257 C'SINK BIT (ENSURE NOT TO C'SINK PAST THE BOTTOM, ONLY CUT THE TOP) AND INSPECT C'SINK WITH A SAMPLE NAS1330C3KB116 INSERT TO ENSURE INSERTS WILL SIT FLUSH, AND HOLE IS NOT OVERSIZED

8- DEBURR INSIDE OF HOLE AS NECESSARY (DO NOT ENLARGE HOLES)
REMOVE ANY FOREIGN OBJECTS INSIDE OF TUBES

9- Countersink crossbolt spacer holes as per Dwg D3274

EL/JR
8-4-9

8-4-11

10.0

D32851

Cap



Comment: Qty.: 1.0000 Each(s)/Unit Total: 1.0000 Each(s)

Pick:

Qty Part Number Description Batch

1 D3285-1

Fwd Cap

B33702

BE 08/04/21

11.0

D2649

Crossbolt Spacer



Comment: Qty.: 12.0000 Each(s)/Unit Total: 12.0000 Each(s)

Pick:

Qty Part Number Description Batch

12 D2649

Crossbolt spacer

B37329

BE 08/04/21

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Date: Wednesday, 10/11/2006 10:30:12 AM
User: Kim Johnston

Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: FLOAT SKIDTUBE ASSEMBLY

Job Number: 28891A

Part Number: D206642545

Job Number:



Seq. #:

Machine Or Operation:

Description :

12.0

D32751

Crossbolt Spacer



Comment: Qty.: 37.0000 Each(s)/Unit Total: 37.0000 Each(s)

Pick:

Qty Part Number Description Batch

37 D3275-1 Crossbolt spacer

B35210 BE 08/04/21

13.0

LANDING GEAR 1

LANDING GEAR RESOURCE 1



Comment: LANDING GEAR RESOURCE 1

1-Weld Fwd Cap as per Dwg D3274 and QSI 004. Use aluminum rod.

A/R Aluminum Rod

m106330/m107263

BE 08/04/21

2-Insert D2649 & D3275-1 crossbolt spacers. Weld as per QSI 004 and Dwg D3274. Remember to back drill each hole before welding the other side. Use aluminum rod

A/R Aluminum Rod

m106330

BE 08/04/21

3-Grind welds flush to Fwd cap on top surface only.

4-Grind cross bolt welds flush as per Dwg D3274. Masking Tape access to inside of the skidtube

5-Counterbore 5/16" x 0.750" deep as per Dwg D3274. Use DT8743 visual aid Jig and deburr.

g422

14.0

QC5/10

WELD INSPECTION



Comment: Inspect weld and Counterbore. Inspect for foreign objects as per QSI 024

15.0

POWDER COATING

POWDER COATING



Comment: POWDER COATING

Powder Coat White Gloss (Ref: 4.3.5.1) as per QSI 005 4.3

M107550

HI 08-01-C

16.0

QC3

INSPECT POWDER COAT/CHEMICAL CONVERSION



Comment: INSPECT POWDER COAT/CHEMICAL CONVERSION

17.0

D3415041

Nut Plate



Comment: Qty.: 1.0000 Each(s)/Unit Total: 1.0000 Each(s)

Pick:

Qty Part Number Description Batch

1 D3415-041 Nut Plate

B28891A
D20664254
24/04/2008
S.111
#1 321.5
#2
#3
#4
WAVE

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Date: Wednesday, 10/11/2006 10:30:13 AM
User: Kim Johnston

Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: FLOAT SKIDTUBE ASSEMBLY

Job Number: 28891A

Part Number: D206642545

Job Number:



Seq. #:

Machine Or Operation:

Description :

18.0

CCR264SS33

Cherry Rivet



Comment: Qty.: 2.0000 Each(s)/Unit Total : 2.0000 Each(s)

Pick:

Qty Part Number Description Batch
2 CCR264SS3-3 Rivet

19.0

CR3212403

Cherry Rivet



Comment: Qty.: 2.0000 Each(s)/Unit Total : 2.0000 Each(s)

Pick:

Qty Part Number Description Batch
2 CR3212-4-03 Rivet

20.0

D26483

Wearpad



Comment: Qty.: 9.0000 Each(s)/Unit Total : 9.0000 Each(s)

Pick:

Qty Part Number Description Batch
9 D2648-3 Wearpad

21.0

D265615

Wearplate



Comment: Qty.: 1.0000 Each(s)/Unit Total : 1.0000 Each(s)

Pick:

Qty Part Number Description Batch
1 D2656-15 Wearshoe

22.0

D265623

Wearplate



Comment: Qty.: 1.0000 Each(s)/Unit Total : 1.0000 Each(s)

Pick:

Qty Part Number Description Batch
1 D2656-23 Wearshoe

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Date: Wednesday, 10/11/2006 10:30:13 AM
User: Kim Johnston

Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: FLOAT SKIDTUBE ASSEMBLY

Job Number: 28891A

Part Number: D206642545

Job Number:



Seq. #:

Machine Or Operation:

Description :

23.0

D265635

Wearplate



Comment: Qty.: 1.0000 Each(s)/Unit Total : 1.0000 Each(s)

Pick:

Qty Part Number Description Batch

1 D2656-35 Wearshoe

24.0

D32871

Wearshoe



Comment: Qty.: 1.0000 Each(s)/Unit Total : 1.0000 Each(s)

Pick:

Qty Part Number Description Batch

1 D3287-1 Wearshoe

25.0

D34291



Comment: Qty.: 1.0000 Each(s)/Unit Total : 1.0000 Each(s)

Pick:

Qty Part Number Description Batch

1 D3429-1 Wearpad

*See D
see attached*

26.0

AN960C10L

washer



Comment: Qty.: 78.0000 Each(s)/Unit Total : 78.0000 Each(s)

Pick:

Qty Part Number Description Batch

78 AN960C10L Washer

W

27.0

MS27039C108

SCREW



Comment: Qty.: 78.0000 Each(s)/Unit Total : 78.0000 Each(s)

Pick:

Qty Part Number Description Batch

78 MS27039C1-08Screw

28.0

NAS1330C3KB116

Insert



Comment: Qty.: 78.0000 Each(s)/Unit Total : 78.0000 Each(s)

Pick:

Qty Part Number Description Batch

78 NAS1330C3KB116 Inserts

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Date: Wednesday, 10/11/2006 10:30:13 AM
User: Kim Johnston

Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: FLOAT SKIDTUBE ASSEMBLY

Job Number: 28891A

Part Number: D206642545

Job Number:



Seq. #:

Machine Or Operation:

Description :

29.0

NAS1515H3L

WASHER



Comment: Qty.: 78.0000 Each(s)/Unit Total : 78.0000 Each(s)

Pick:

Qty Part Number Description Batch

78 NAS1515H3L Washer _____

30.0

D34131

Ring



Comment: Qty.: 1.0000 Each(s)/Unit Total : 1.0000 Each(s)

Pick:

Qty Part Number Description Batch

1 D3413-1 Ring _____

31.0

AN4C5A

BOLT



Comment: Qty.: 1.0000 Each(s)/Unit Total : 1.0000 Each(s)

Pick:

Qty Part Number Description Batch

1 AN4C5A Bolt _____

32.0

AN960C416L

WASHER



Comment: Qty.: 1.0000 Each(s)/Unit Total : 1.0000 Each(s)

Pick:

Qty Part Number Description Batch

1 AN960C416L Washer _____

33.0

NAS1515H4L

Inventory



Comment: Qty.: 1.0000 Each(s)/Unit Total : 1.0000 Each(s)

Pick:

Qty Part Number Description Batch

1 NAS1515H4L Washer _____

34.0

D2646

Aft Cap



Comment: Qty.: 1.0000 Each(s)/Unit Total : 1.0000 Each(s)

Pick:

Qty Part Number Description Batch

1 D2646 Aft Cap _____

REV D
see 2H schedule

W

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Date: Wednesday, 10/11/2006 10:30:13 AM
User: Kim Johnston

Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: FLOAT SKIDTUBE ASSEMBLY

Job Number: 28891A

Part Number: D206642545

Job Number:



Seq. #:	Machine Or Operation:	Description :
---------	-----------------------	---------------

35.0	AN960C10L	washer
------	-----------	--------



Comment: Qty.: 2.0000 Each(s)/Unit Total : 2.0000 Each(s)

Pick:

Qty Part Number Description Batch

2 AN960C10L Washer

36.0	MS27039C108	SCREW
------	-------------	-------



Comment: Qty.: 2.0000 Each(s)/Unit Total : 2.0000 Each(s)

Pick:

Qty Part Number Description Batch

2 MS27039C1-08Screw

37.0	NAS1515H3L	WASHER
------	------------	--------



Comment: Qty.: 2.0000 Each(s)/Unit Total : 2.0000 Each(s)

Pick:

Qty Part Number Description Batch

2 NAS1515H3L Washer

Rev. D
all attached
u

38.0	HAND FINISHING1	HAND FINISHING RESOURCE #1
------	-----------------	----------------------------



Comment: HAND FINISHING RESOURCE #1

1-Install Nut Plate as per Dwg D3274. Apply LPS-3 to Nut Plate and rivets.

A/RN/ALPS-3

2-Install inserts & wearpads as per Dwg D3274. Use a drop of Sikaflex inside insert holes and a layer of sikaflex between wearplates and skidtube.

A/R Sikaflex-291

Sikaflex expire date:

3-Install ring as per Dwg D3274

A/R Sikaflex-291

Sikaflex expire date:

4-Inspect for foreign objects as per QSI 024

5-Spray inside of tube on both sides of web with LPS-3

A/R LPS-3 Batch:

6-Install Aft Cap and seal with Sikaflex. Clean excess adhesive.

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Date: Wednesday, 10/11/2006 10:30:14 AM
User: Kim Johnston

Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: FLOAT SKIDTUBE ASSEMBLY

Job Number: 28891A

Part Number: D206642545

Job Number:



Seq. #:

Machine Or Operation:

Description :

A/R Sikaflex-291 _____
Sikaflex expire date: _____

39.0

QC5

INSPECT WORK TO CURRENT STEP



Comment: INSPECT WORK TO CURRENT STEP

40.0

QC21

FINAL INSPECTION/W/O RELEASE



Comment: FINAL INSPECTION/W/O RELEASE

Job Completion



W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

DART

DESIGN CP	DRAWN BY CP	DART AEROSPACE USA, INC. PORT HADLOCK, WA	
CHECKED <i>[Signature]</i>	APPROVED <i>[Signature]</i>	DRAWING NO. D3274	REV. C SHEET 1 OF 4
DATE 05.03.16		TITLE SKIDTUBE ASSEMBLY	SCALE NTS
A	04.03.15	NEW ISSUE	
B	04.08.09	MOVE SADDLE HOLE: 42.14 WAS 42.76	
C	05.03.16	ADD -043; NEW INSERTS	

RELEASED
05-09-06 *[Signature]*

Qty -041	Qty -043	Part Number	Description
X		D3274-041	SKIDTUBE ASSEMBLY
	X	D3274-043	SKIDTUBE ASSEMBLY
1	1	D2600-1-240	EXTRUSION
9	9	D2648-3	WEARPAD
12	12	D2649	CROSS BOLT SPACER
1	1	D2656-15	WEARSHOE
1	1	D2656-23	WEARSHOE
1	1	D2656-35	WEARSHOE
12	37	D3275-1	CROSS BOLT SPACER
1	1	D3282-041	FLOAT WEB
1	1	D3285-1	CAP
1	1	D3287-1	WEARSHOE
1	1	D2646	AFT CAP
1	1	D3413-1	RING
1	1	D3415-041	NUT PLATE
1	1	D3429-1	WEARPAD
78	78	NAS1330C3KB116	INSERT
80	80	NAS1515H3L	WASHER
1	1	NAS1515H4	WASHER
2	2	CCR264SS3-3	RIVET
2	2	CR3212-4-03	RIVET
80	80	MS27039C1-08	SCREW
1	1	AN4C5A	BOLT

GENERAL NOTES:

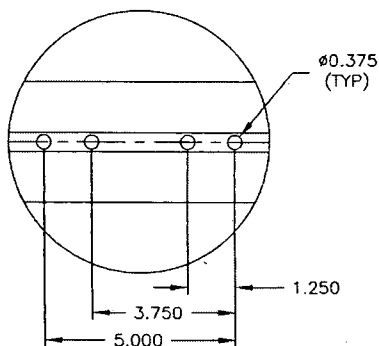
1. TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED.
2. DAMAGE TOLERANCE ON FWD BEND:
THERE SHOULD BE NO VISIBLE WRINKLES IN THE BEND FROM THE GROUND TO A HEIGHT OF 7 INCHES ABOVE THE GROUND. IT IS ACCEPTABLE TO POLISH OUT GOUGES UP TO 0.020 DEEP IN THE BENT PORTION OF THE TUBE. A MAXIMUM REDUCTION IN DIAMETER OF 0.150" IS ACCEPTABLE IN THE BENT PORTION OF THE TUBE.
3. ALL HOLES DRILLED ON CENTERLINES.
4. BOND D3282-041 FLOAT WEB INTO D3274-1/-3 OUTER TUBE WITH NON-STRUCTURAL SIKAFLEX-241/291 ADHESIVE PER DART QSI 015. ENSURE HOLES LINE-UP.
5. WELDING TO BE DONE PER DART QSI 004.
6. FINISH: - ACID ETCH, ALODINE ASSEMBLY PER DART QSI 005 4.1
- POWDER COAT WHITE (REF. 4.3.5.1) PER DART QSI 005 4.3
7. DRILL 'E' (Ø0.250 REF) AND C'SINK Ø0.391x100° FOR NAS1330C3KB116 INSERT USING DT3274-1T2 BEFORE FINISH. INSTALL NAS1330C3KB116 INSERTS AFTER FINISH WITH LPS LABORATORIES "LPS-3".
8. WEARPLATES TO BE INSTALLED WITH A LAYER OF SIKAFLEX-241/-291 ADHESIVE BETWEEN WEARPLATES AND SKIDTUBE.
9. SPRAY INSIDE OF TUBE WITH A COAT OF LPS LABORATORIES "LPS-3" AFTER FINISH AND INSTALLATION OF INSERTS. COAT ALL EXPOSED FASTENERS WITH LPS LABORATORIES "LPS PROCYON" AFTER FINAL ASSEMBLY, CLEAN EXCESS OFF POWDER COATING WITH MEK DESGREASER.

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WORK ORDER
NO. **2889** 1A

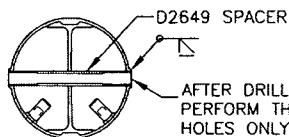
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DETAIL A: DRILL DETAIL

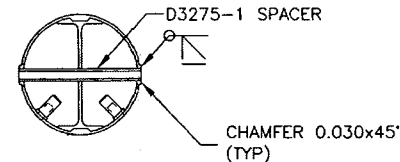


DETAIL B FOR 0.375 HOLES ONLY



- AFTER DRILLING AND BENDING ASSEMBLY
PERFORM THE FOLLOWING FOR 0.375
HOLES ONLY:
1. CHAMFER HOLE 0.030x45°
 2. INSERT D2649 SPACER
 3. WELD INTO PLACE AND GRIND FLUSH
 4. C'BORE TO 0.313x0.75 DEEP

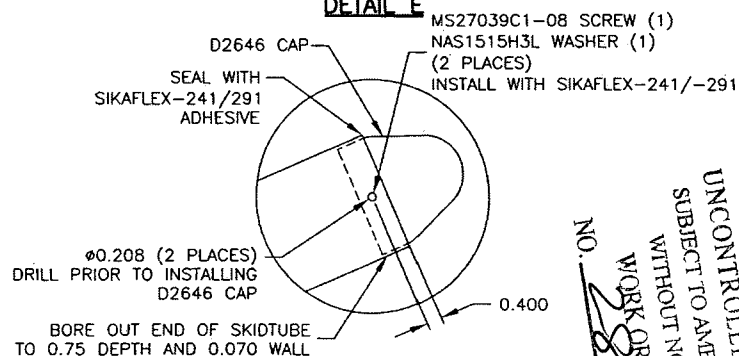
DETAIL C FOR 0.313 HOLES ONLY



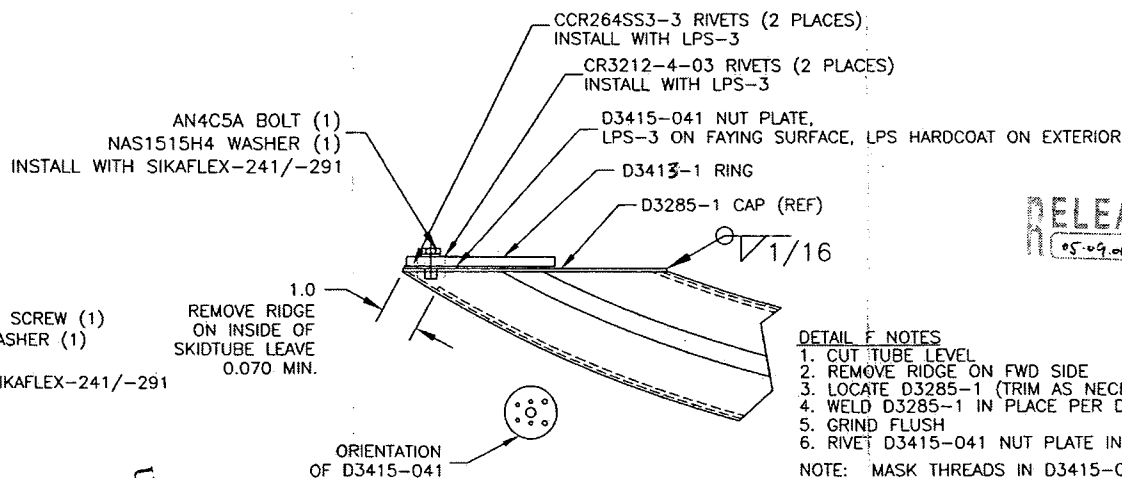
DETAIL D



DETAIL E



DETAIL F: END FINISHING DETAIL

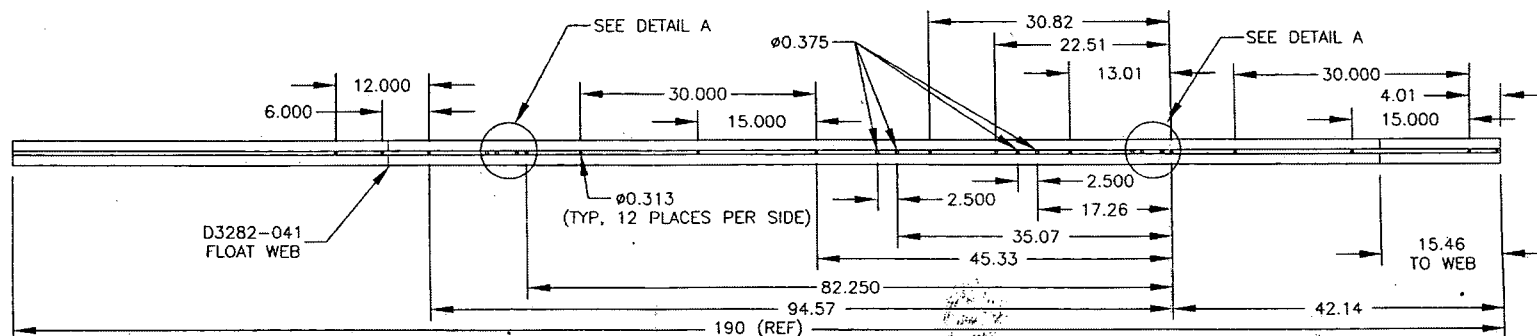


- DETAIL F NOTES**
1. CUT TUBE LEVEL
 2. REMOVE RIDGE ON FWD SIDE
 3. LOCATE D3285-1 (TRIM AS NECESSARY)
 4. WELD D3285-1 IN PLACE PER DART QSI 004
 5. GRIND FLUSH
 6. RIVET D3415-041 NUT PLATE IN PLACE
- NOTE: MASK THREADS IN D3415-041 PRIOR TO FINISH

RELEASED
05-09-06

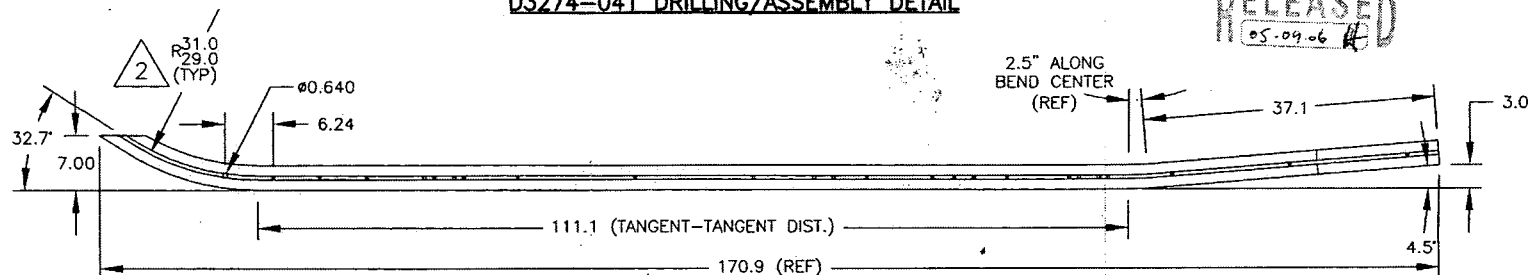
NO. 28831
WORK ORDER
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CHECKED	DATE	CP	CP	
05.03.16				DRAWING NO. D3274
				REV. C SHEET 2 OF 4
				TITLE SKIDTUBE ASSEMBLY
				SCALE 1 TO 3

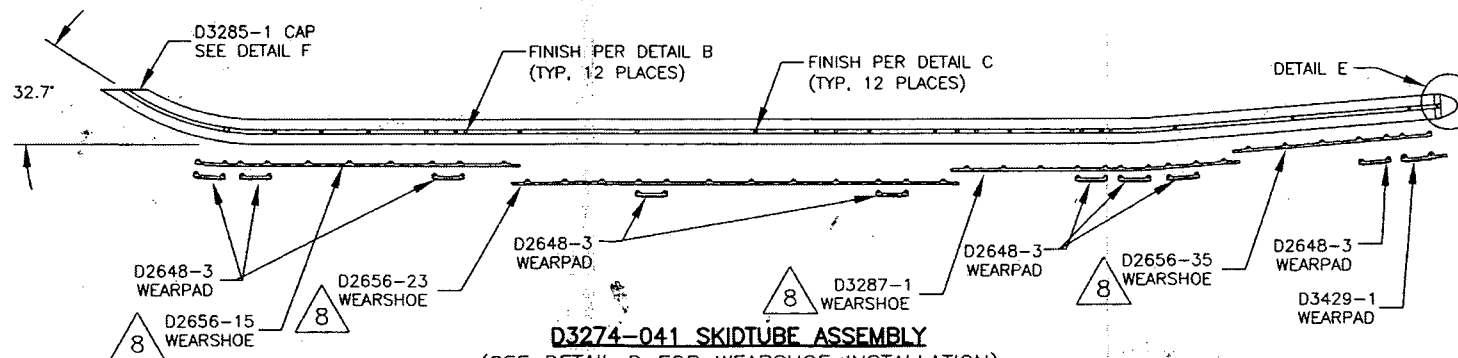


D3274-041 DRILLING/ASSEMBLY DETAIL

RELEASED
05-09-06



D3274-041 BEND/DRILLING DETAIL

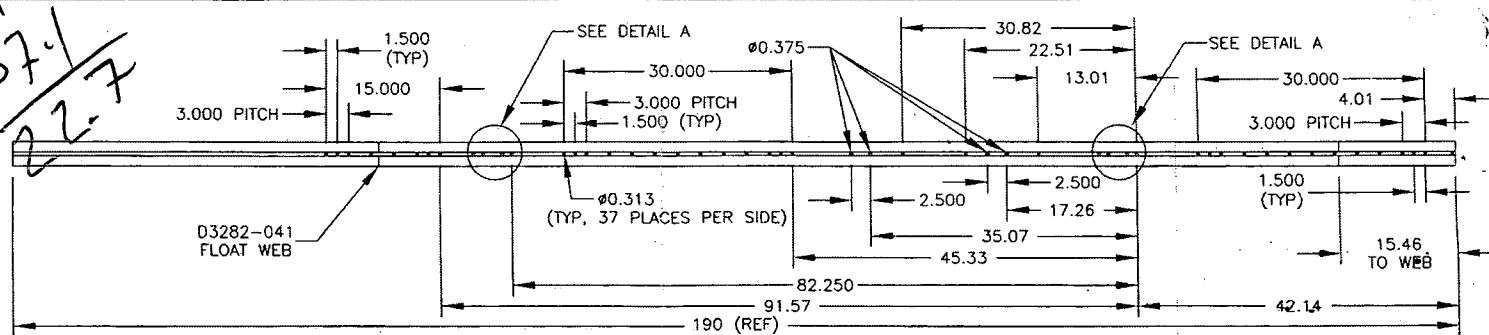


D3274-041 SKIDTUBE ASSEMBLY
(SEE DETAIL D FOR WEARSHOE INSTALLATION)

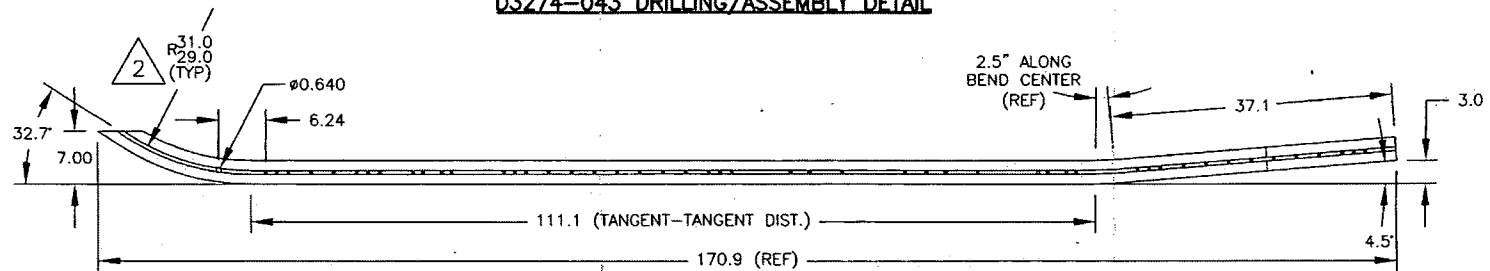
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DATE 05.03.16		CHECKED #	APPROVED #	TITLE SKIDTUBE ASSEMBLY	SHEET 3 OF 4 1:15

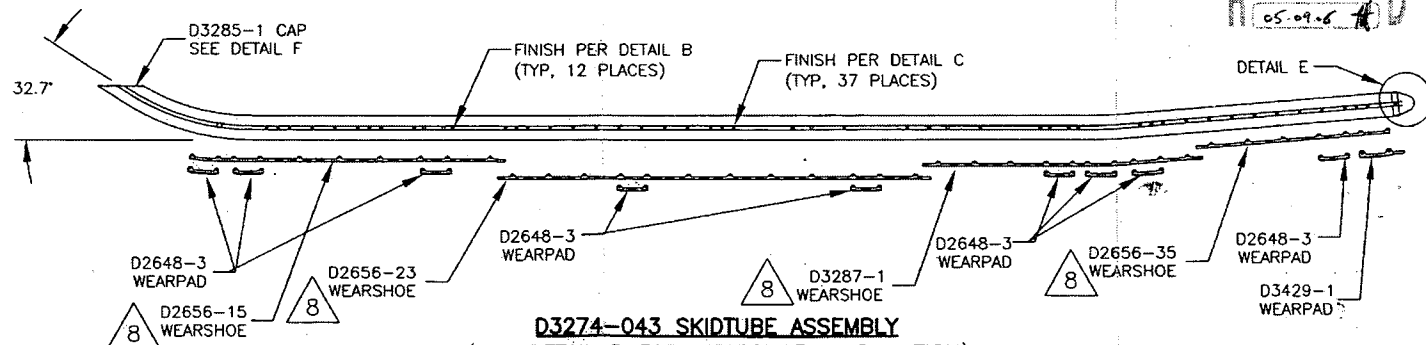
1709
 111.1
 59.8
 37.1
 22.7



D3274-043 DRILLING/ASSEMBLY DETAIL



D3274-043 BEND/DRILLING DETAIL



D3274-043 SKIDTUBE ASSEMBLY
 (SEE DETAIL D FOR WEARSHOE INSTALLATION)

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		DATE 05.03.16	TITLE SKIDTUBE ASSEMBLY	
				REV. C SHEET 4 OF 4 SCALE 1:15

NO. 146

AWS D17.1.2001
QUALIFICATION TEST RECORD

Name: Barclay Elliot
Job number: 37704A
Part number: D058 612 041
Description: oil-se skid tube
Welding Process: Tig ☒ Mig ☐
Base material: Aluminium
Current: AC ☒ DC ☐

TEST REQUIREMENTS AND RESULTS

Visual: pass ☒ fail ☐
Penetration: pass ☒ fail ☐

UNACCEPTABLE

Cracks: pass ☒ fail ☐
Undercut: pass ☒ fail ☐
Pin holes: pass ☒ fail ☐
Overlap (cold lap): pass ☒ fail ☐
Porosity (surface): pass ☒ fail ☐
Coloration: pass ☒ fail ☐

Qualifier Pat. Dupel Date of Test Coupon 08-03-28

Welder Barclay Elliot Date of Test Coupon 08-03-28

The above named individual is qualified in accordance with AWS D17.1.2001 to weld

Date: Friday, 25/04/2008 10:59:49 AM
 User: Linda Lacelle

Process Sheet

Customer :	CU-DAR001 Dart Helicopters Services	Drawing Name :	FLOAT SKIDTUBE ASSEMBLY
Job Number :	28891A		
Estimate Number :	12548		
P.O. Number :		Part Number :	D206642545
This Issue :	25/04/2008	Drawing Number :	D3274 REV C Rev D <i>CP 02-05-24</i>
Prsht Rev. :	NC	Project Number :	N/A
First Issue :	11/10/2006	Drawing Revision :	<i>SD</i>
Previous Run :	28890A	Material :	
Written By :	<i>[Signature]</i>	Due Date :	05/11/2006
Checked & Approved By :	<i>[Signature]</i>	Qty:	1
Comment :	Est Rev:A New Issue 06-10-06 JLM	Um:	Each

Additional Product

Job Number:



Seq. #:	Machine Or Operation:	Description :
16.0	QC3	INSPECT POWDER COAT/CHEMICAL CONVERSION



Comment: INSPECT POWDER COAT/CHEMICAL CONVERSION

FD 08/05/02 (1)

17.0	D3415041	Nut Plate
------	----------	-----------



Comment: Qty.: 1.0000 Each(s)/Unit Total : 1.0000 Each(s)

Pick:

Qty	Part Number	Description	Batch
1	D3415-041	Nut Plate	<i>B33842</i>

FD.

18.0	CCR264SS33	Cherry Rivet
------	------------	--------------



Comment: Qty.: 2.0000 Each(s)/Unit Total : 2.0000 Each(s)

Pick:

Qty	Part Number	Description	Batch
2	CCR264SS3-3	Rivet	<i>m106825</i>

FD.

19.0	CR3212403	Cherry Rivet
------	-----------	--------------



Comment: Qty.: 2.0000 Each(s)/Unit Total : 2.0000 Each(s)

Pick:

Qty	Part Number	Description	Batch
2	CR3212-4-03	Rivet	<i>m15918</i>

FD. 08/05/02 (1)

Date: Friday, 25/04/2008 10:59:49 AM
User: Linda Lacelle

Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: FLOAT SKIDTUBE ASSEMBLY

Job Number: 28891A

Part Number: D206642545

Job Number:



Seq. #:

Machine Or Operation:

Description :

20.0

ALS71032130

Insert



Comment: Qty.: 78.0000 Each(s)/Unit Total : 78.0000 Each(s)

Insert

Batch: m105819

Fl.

21.0

HAND FINISHING1

HAND FINISHING RESOURCE #1



Comment: HAND FINISHING RESOURCE #1

1-Install Nut Plate as per Dwg D3274. Apply LPS-3 to Nut Plate and rivets.

A/RN/ALPS-3 m105005

2-Install inserts as per Dwg D3274. Use a drop of Sikaflex inside insert holes a

A/R Sikaflex-291 m107804

Sikaflex expire date: 08/10

08/05/02 (P)

22.0

QC5

INSPECT WORK TO CURRENT STEP



Comment: INSPECT WORK TO CURRENT STEP

Inspect Nut Plate & Inserts

1 (A) 08/05/02 (P)

23.0

AN3C4A

BOLT



Comment: Qty.: 80.0000 Each(s)/Unit Total : 80.0000 Each(s)

BOLT

Batch: m107715 (x59)

m107242 (x21) Fl.

24.0

D353515

Wearshoe



Comment: Qty.: 1.0000 Each(s)/Unit Total : 1.0000 Each(s)

WEARSHOE

Batch: B37810

Fl.

25.0

D353523

Wearshoe



Comment: Qty.: 1.0000 Each(s)/Unit Total : 1.0000 Each(s)

WEARSHOE

Batch: B35218

Fl. 08/05/05 (P)

Date: Friday, 25/04/2008 10:59:49 AM
User: Linda Lacelle

Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: FLOAT SKIDTUBE ASSEMBLY

Job Number: 28891A

Part Number: D206642545

Job Number:



Seq. #:

Machine Or Operation:

Description :

26.0

D353535

Wearshoe



Comment: Qty.: 1.0000 Each(s)/Unit Total : 1.0000 Each(s)

WEARSHOE

Batch: B38760

FD.

27.0

D353539

Wearshoe



Comment: Qty.: 1.0000 Each(s)/Unit Total : 1.0000 Each(s)

WEARSHOE

Batch: B37277

FD.

28.0

D353615

Gasket



Comment: Qty.: 1.0000 Each(s)/Unit Total : 1.0000 Each(s)

GASKET

Batch: B33964

FD.

29.0

D353623

Gasket



Comment: Qty.: 1.0000 Each(s)/Unit Total : 1.0000 Each(s)

GASKET

Batch: B33965

FD.

30.0

D353635

Gasket



Comment: Qty.: 1.0000 Each(s)/Unit Total : 1.0000 Each(s)

GASKET

Batch: B37352

FD.

31.0

D353639

Gasket



Comment: Qty.: 1.0000 Each(s)/Unit Total : 1.0000 Each(s)

GASKET

Batch: B33966

FD.

32.0

D35371

Wearpad



Comment: Qty.: 9.0000 Each(s)/Unit Total : 9.0000 Each(s)

WEARPAD

Batch: B36426

FD 08/05/05 ①

Date: Friday, 25/04/2008 10:59:49 AM
User: Linda Lacelle

Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: FLOAT SKIDTUBE ASSEMBLY

Job Number: 28891A

Part Number: D206642545

Job Number:



Seq. #:

Machine Or Operation:

Description :

33.0

D35373

Wearpad



Comment: Qty.: 1.0000 Each(s)/Unit Total: 1.0000 Each(s)
WEARPAD

1533881

FL

34.0

AN960C10L

washer



Comment: Qty.: 80.0000 Each(s)/Unit Total: 80.0000 Each(s)
Pick:

Qty Part Number Description Batch
80 AN960C10L Washer

m107137

FL

35.0

D36721

Phenolic Washer



Comment: Qty.: 2.0000 Each(s)/Unit Total: 2.0000 Each(s)
Washer
batch

634470

FL

36.0

D34131

Ring



Comment: Qty.: 1.0000 Each(s)/Unit Total: 1.0000 Each(s)
Pick:

Qty Part Number Description Batch
1 D3413-1 Ring

1533949

FL

37.0

AN4C5A

BOLT



Comment: Qty.: 1.0000 Each(s)/Unit Total: 1.0000 Each(s)
Pick:

Qty Part Number Description Batch
1 AN4C5A Bolt

m104936

FL

38.0

AN960C416L

WASHER



Comment: Qty.: 1.0000 Each(s)/Unit Total: 1.0000 Each(s)
Pick:

Qty Part Number Description Batch
1 AN960C416 Washer

m107008

FL 08/05/05 (1)

Date: Friday, 25/04/2008 10:59:49 AM
User: Linda Lacelle

Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: FLOAT SKIDTUBE ASSEMBLY

Job Number: 28891A

Part Number: D206642545

Job Number:



Seq. #:

Machine Or Operation:

Description :

39.0

D2646

Aft Cap



PLD →

Comment: Qty.: 1.0000 Each(s)/Unit Total: 1.0000 Each(s)

Pick:

Qty Part Number

Description Batch

1 D2646

Aft Cap

037755

FL

40.0

HAND FINISHING1

HAND FINISHING RESOURCE #1



Comment: HAND FINISHING RESOURCE #1

2-Install wearpads & gaskets as per Dwg D3274.

3-Install ring as per Dwg D3274

A/R Sikaflex-291

m107804

Sikaflex expire date:

08/10

4-Inspect for foreign objects as per QSI 024

5-Spray inside of tube on both sides of web with LPS-3

A/R LPS-3

Batch: m105005

6-Install Aft Cap and seal with Sikaflex. Clean excess adhesive.

A/R Sikaflex-291

m107804

Sikaflex expire date:

08/10

FL 08/05/05 ①

41.0

QC5

INSPECT WORK TO CURRENT STEP



Comment: INSPECT WORK TO CURRENT STEP

08/05/05 ②

42.0

QC21

FINAL INSPECTION/W/O RELEASE





Comment: FINAL INSPECTION/W/O RELEASE


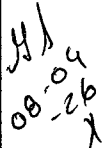



Job Completion



MF 08-09-29

W/O:		WORK ORDER CHANGES						
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector	
08.09.26	1	COPY BLUEPRINT & LABELS FOR <u>CHG002</u> TUBE ACCEPTABLE TO D3274 Rev.D				 08.09.26 PC Q31042	 08/09/26	

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes ☒ No ☐ DQA: D Date: 08/09/26
QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			
		Demarcus removed Aft cap was damaged R.C. 2. head fix was too old and to hard	 08/09/26	Scrap and destroy and replace Bk <u>41435</u>	 08-09-26 X1	 08/09/26	 08/09/26	 08/09/26

NOTE: Date & initial all entries



DESIGN CP	DRAWN BY PH	DART AEROSPACE USA, INC. PORT HADLOCK, WA	
CHECKED [Signature]	APPROVED [Signature]	DRAWING NO. D3274	REV. D SHEET 1 OF 4
DATE 06.12.19		TITLE SKIDTUBE ASSEMBLY	SCALE NTS
A	04.03.15	NEW ISSUE	
B	04.08.09	MOVE SADDLE HOLE: 42.14 WAS 42.76	
C	05.03.16	ADD -043; NEW INSERTS	
D	06.12.19	NEW INSERTS, SS WEARSHOE + GASKET	

RELEASED

07.02.12 **[Signature]**

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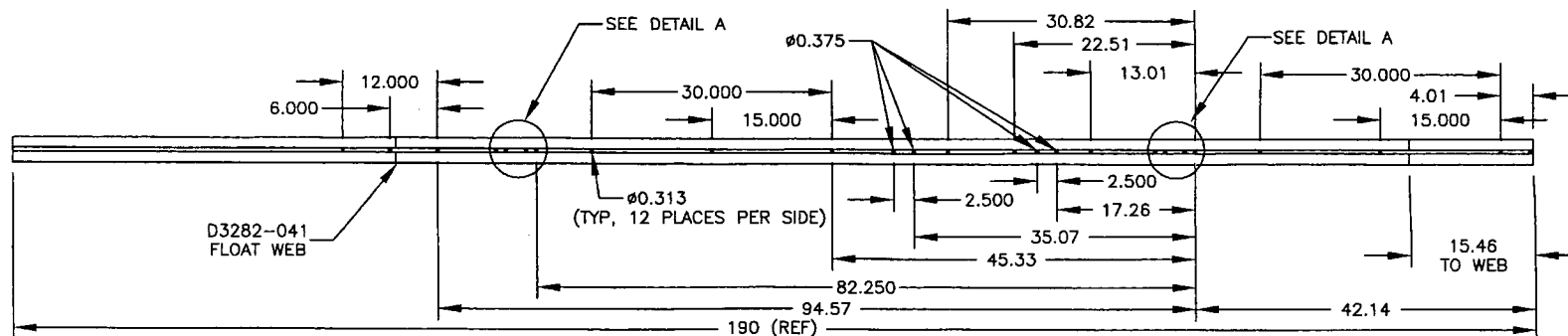
Qty -041	Qty -043	Part Number	Description
X		D3274-041	SKIDTUBE ASSEMBLY
	X	D3274-043	SKIDTUBE ASSEMBLY
1	1	D2600-1-240	EXTRUSION
1	1	D2646	AFT CAP
12	12	D2649	CROSS BOLT SPACER
12	37	D3275-1	CROSS BOLT SPACER
1	1	D3282-041	FLOAT WEB
1	1	D3285-1	CAP
1	1	D3413-1	RING
1	1	D3415-041	NUT PLATE
1	1	D3535-15	WEARSHOE
1	1	D3535-23	WEARSHOE
1	1	D3535-35	WEARSHOE
1	1	D3535-39	WEARSHOE
1	1	D3536-15	GASKET
1	1	D3536-23	GASKET
1	1	D3536-35	GASKET
1	1	D3536-39	GASKET
9	9	D3537-1	WEARPAD
1	1	D3537-3	WEARPAD
78	78	ALS7-1032-130	INSERT (or AKS4-1032-130, ALS4-1032-130, AELS-1032-130)
80	80	AN3C4A	BOLT
1	1	AN4C5A	BOLT
1	1	AN960C416	WASHER
80	80	AN960C10L	WASHER
2	2	CCR264SS3-3	RIVET
2	2	CR3212-4-03	RIVET
2	2	NAS1515H3L	WASHER

GENERAL NOTES:

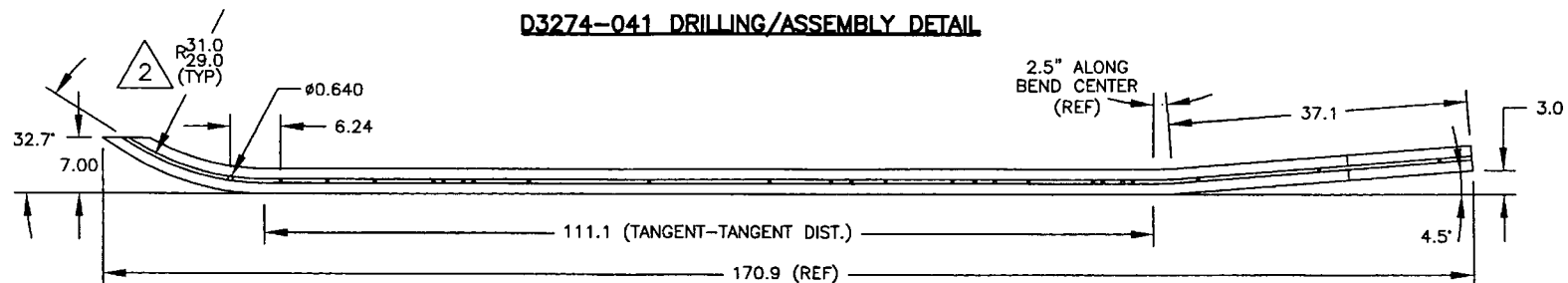
1. TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED.
2. DAMAGE TOLERANCE ON FWD BEND:
THERE SHOULD BE NO VISIBLE WRINKLES IN THE BEND FROM THE GROUND TO A HEIGHT OF 7 INCHES ABOVE THE GROUND. IT IS ACCEPTABLE TO POLISH OUT GOUGES UP TO 0.020 DEEP IN THE BENT PORTION OF THE TUBE. A MAXIMUM REDUCTION IN DIAMETER OF 0.150" IS ACCEPTABLE IN THE BENT PORTION OF THE TUBE.
3. ALL HOLES DRILLED ON CENTERLINES.
4. BOND D3282-041 FLOAT WEB INTO D3274-1/-3 OUTER TUBE WITH NON-STRUCTURAL SIKAFLEX-241/291 ADHESIVE PER DART QSI 015. ENSURE HOLES LINE-UP.
5. WELDING TO BE DONE PER DART QSI 004.
6. FINISH: - ACID ETCH, ALODINE ASSEMBLY PER DART QSI 005 4.1
- POWDER COAT WHITE (REF. 4.3.5.1) PER DART QSI 005 4.3
7. DRILL Ø0.297 HOLES FOR ALS7-1032-130 INSERTS USING DT3274-1T2 BEFORE FINISH. INSTALL ALS7-1032-130 INSERTS AFTER FINISH. SEAL WEARSHOE BOLTS WITH SIKAFLEX -241/-291.
8. SPRAY INSIDE OF TUBE WITH A COAT OF LPS LABORATORIES "LPS-3" AFTER FINISH AND INSTALLATION OF INSERTS. COAT ALL EXPOSED FASTENERS WITH LPS LABORATORIES "LPS PROCYON" AFTER FINAL ASSEMBLY, CLEAN EXCESS OFF POWDER COATING WITH MEK DEGREASER.

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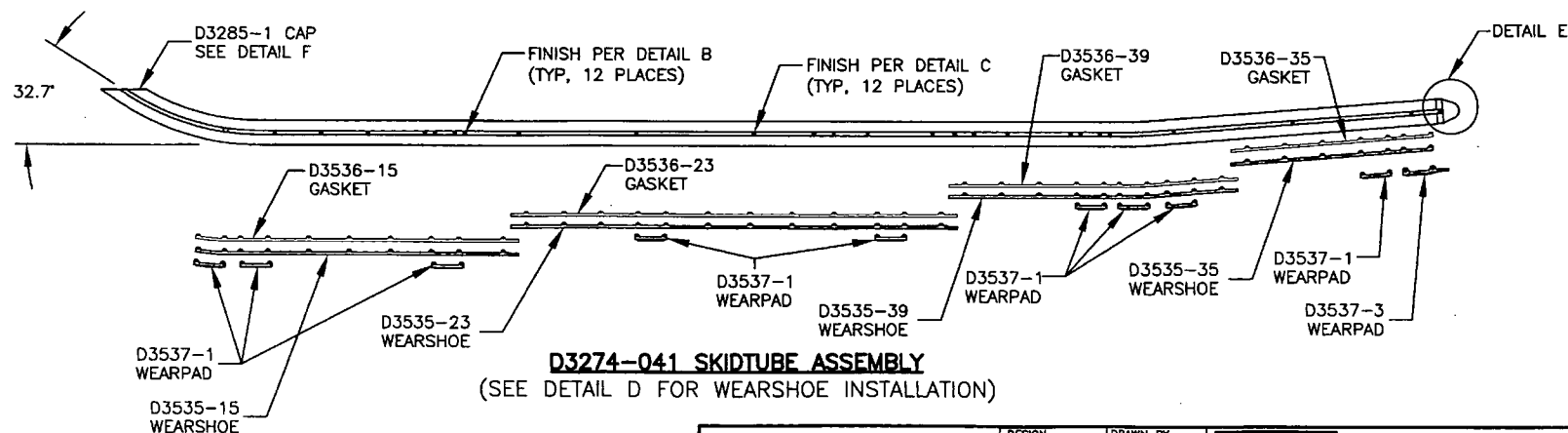
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D3274-041 DRILLING/ASSEMBLY DETAIL



D3274-041 BEND/DRILLING DETAIL



D3274-041 SKIDTUBE ASSEMBLY
(SEE DETAIL D FOR WEARSHOE INSTALLATION)

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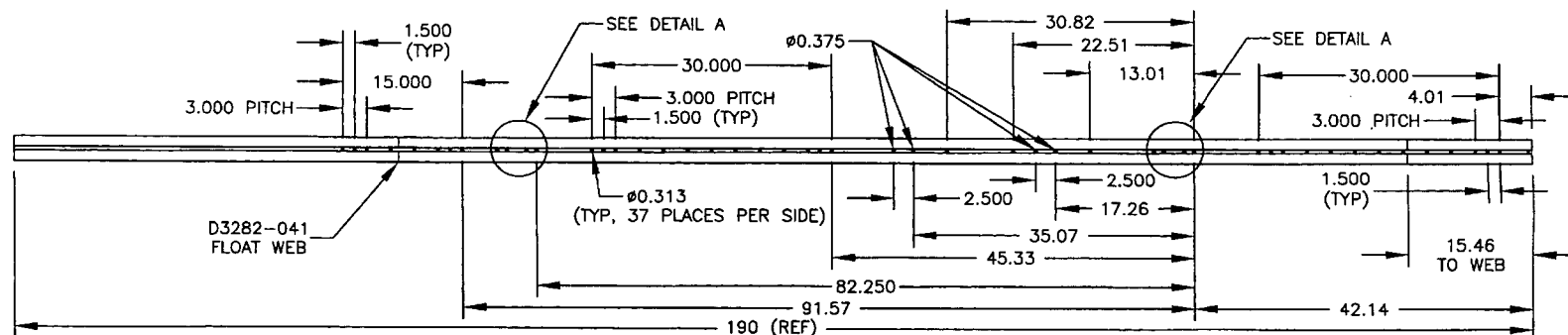
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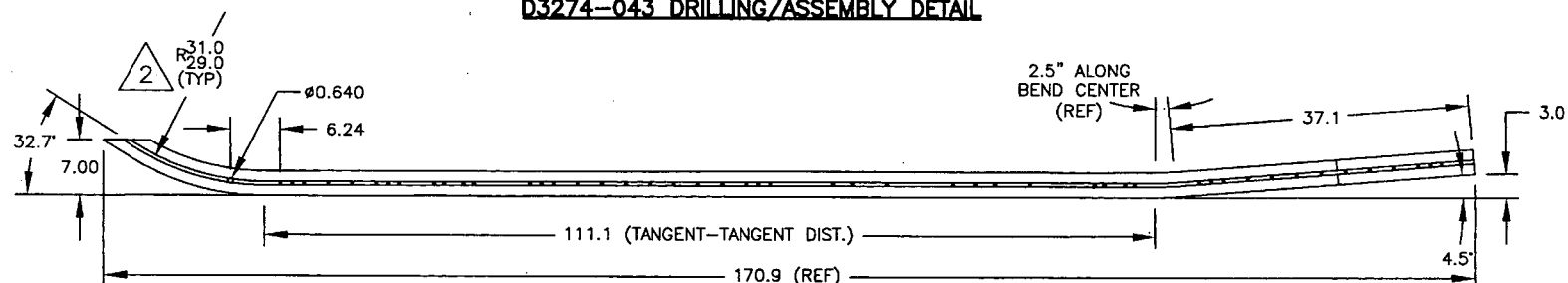
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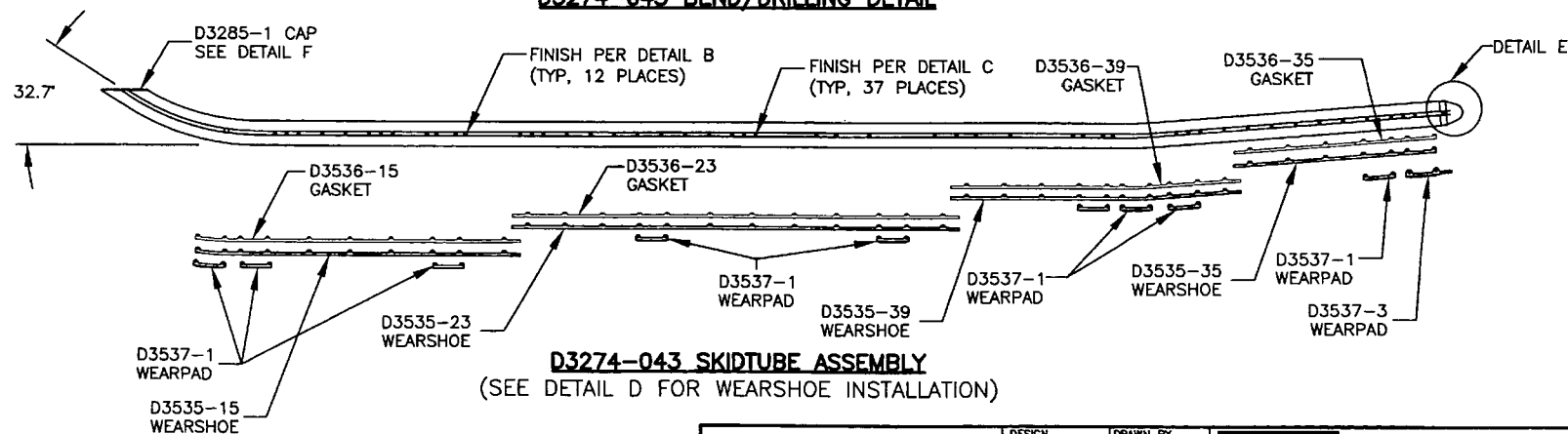
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CHECKED	#	APPROVED	#	DRAWING NO. D3274	SHEET 2 OF 4
DATE	06.12.19	TITLE	SKIDTUBE ASSEMBLY	SCALE	1:15



D3274-043 DRILLING/ASSEMBLY DETAIL



D3274-043 BEND/DRILLING DETAIL



D3274-043 SKIDTUBE ASSEMBLY
(SEE DETAIL D FOR WEARSHOE INSTALLATION)

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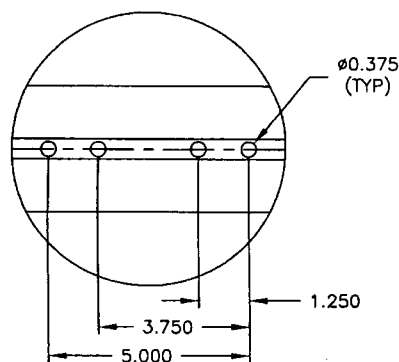
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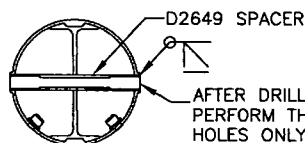
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DESIGN CP	DRAWN BY PH	DART DART AEROSPACE USA, INC. PORT HADLOCK, MA	
CHECKED H	APPROVED H	DRAWING NO. D3274	REV. 0 SHEET 3 OF 4
DATE 06.12.19	TITLE SKIDTUBE ASSEMBLY		SCALE 1:15

DETAIL A: DRILL DETAIL

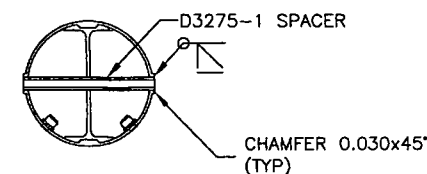


DETAIL B FOR 0.375 HOLES ONLY



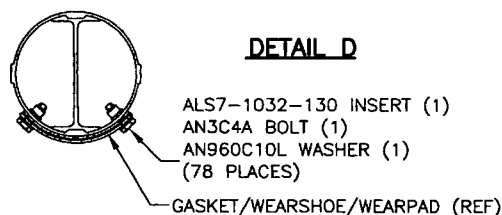
- AFTER DRILLING AND BENDING ASSEMBLY
PERFORM THE FOLLOWING FOR 0.375
HOLES ONLY:
1. CHAMFER HOLE 0.030x45°
 2. INSERT D2649 SPACER
 3. WELD INTO PLACE AND GRIND FLUSH
 4. C'BORE TO 0.313x0.75 DEEP

DETAIL C FOR 0.313 HOLES ONLY



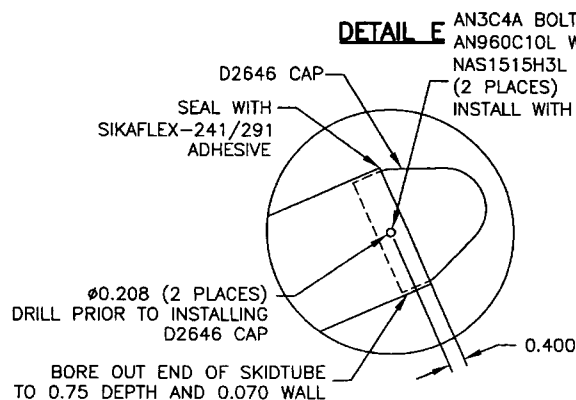
SHOP COPY
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WORK ORDER
NO. 78651A

DETAIL D



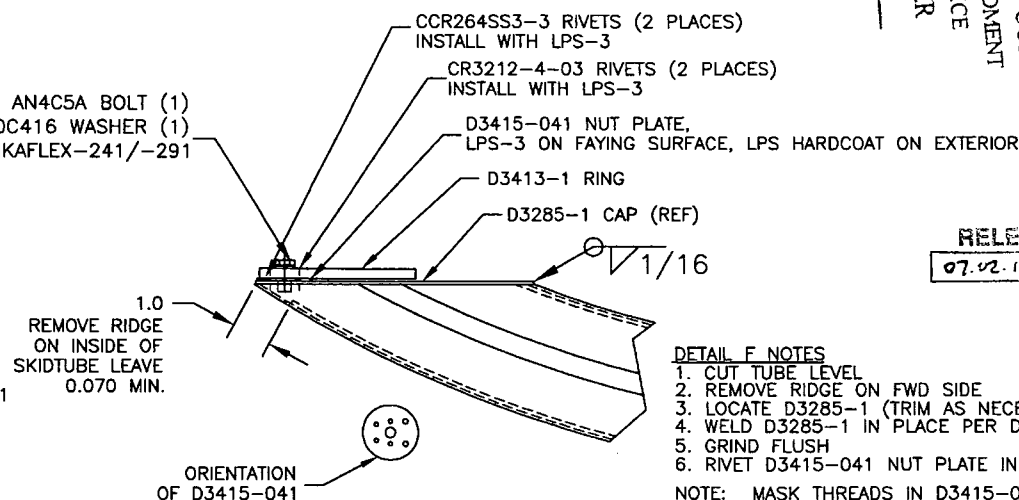
- ALS7-1032-130 INSERT (1)
AN3C4A BOLT (1)
AN960C10L WASHER (1)
(78 PLACES)
GASKET/WEARSHOE/WEARPAD (REF)

DETAIL E



- AN3C4A BOLT (1)
AN960C10L WASHER (1)
NAS1515H3L WASHER (1)
(2 PLACES)
INSTALL WITH SIKAFLEX-241/-291

DETAIL F: END FINISHING DETAIL



- AN4C5A BOLT (1)
AN960C416 WASHER (1)
INSTALL WITH SIKAFLEX-241/-291

- CCR264SS3-3 RIVETS (2 PLACES)
INSTALL WITH LPS-3
CR3212-4-03 RIVETS (2 PLACES)
INSTALL WITH LPS-3
D3415-041 NUT PLATE,
LPS-3 ON FAYING SURFACE, LPS HARDCOAT ON EXTERIOR
D3413-1 RING
D3285-1 CAP (REF)

DETAIL F NOTES

1. CUT TUBE LEVEL
 2. REMOVE RIDGE ON FWD SIDE
 3. LOCATE D3285-1 (TRIM AS NECESSARY)
 4. WELD D3285-1 IN PLACE PER DART QSI 004
 5. GRIND FLUSH
 6. RIVET D3415-041 NUT PLATE IN PLACE
- NOTE: MASK THREADS IN D3415-041
PRIOR TO FINISH

RELEASED
07.02.12

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DESIGN	CP	DRAWN BY	PH	DART DART AEROSPACE USA, INC. PORT HADLOCK, MA
CHECKED	H	APPROVED	H	DRAWING NO. D3274
DATE	06.12.19	TITLE	SKIDTUBE ASSEMBLY	REV. D SHEET 4 OF 4 SCALE 1:3